



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2932-2BL
Job Sheet 167804



split
(15)

Part No: D2932-2BL

Job Qty: 10 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/17/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Rev C.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/15/17	0.00	0.00	Start Up Machining		<i>SBL 17/12/00</i>
100	CNC Vertical Machining	10 pcs		11/16/17	0.40	15.13	HAAS 1		<i>FK 17-12-8</i>
110	Mill Conv	10 pcs		11/16/17	0.00	15.11	Mill Conv 1		<i>FK 17-12-8</i>
120	QC	10 pcs		11/16/17	0.00	0.00	QC1		<i>FK 17-12-8</i>
130	QC	10 pcs		11/16/17	0.00	0.00	QC8		<i>A.E 17-12-11</i>
140	HandFinish	10 pcs		11/16/17	0.00	0.50	HandFinish1		<i>2017-12-12 JSC</i>
150	SprayPaint	10 pcs		11/17/17	0.00	0.75	Spray Paint	<i>Outsource</i>	<i>17-12-17</i>
160	QC	10 pcs		11/17/17	0.00	0.00	QC14		<i>PD 17-12-17</i>
170	Packaging	10 pcs		11/17/17	0.00	0.00	Packaging3	<i>ST 389</i>	<i>BEB 18-12-17</i>
180	QC21-SA	10 Ea		11/17/17	0.00	0.00	QC21		<i>DAS 13 9-89</i>

Part Op 100 - Program part number and batch number.
Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet
150 - ***MASK ALL HOLES AS PAR16-484*** SPRAY PAINT BLEU

DEC 14 2017
P19.30646

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-003	10	18	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

 DART AEROSPACE S018221		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
			
Saddle RH Out, 206			
PART NO: Revision: Operation: Change No:		D2932 – 2BL Start up Operation	
		Mfg Date: 12/06/17 Job No: 167804	
DISPOSITION			
☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab	
Step #: _____		QTY Effective _____	
Description Work Order Deviation			
Root Cause		F	
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete Contamination Countersink Cut Too Short Instructions Incomplete Drill Holes
OTHER : _____			

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.117	.117	.117	.117		
B	0.100	0.140		.116	.115	.115	.115		
C	0.100	0.140		.118	.117	.115	.117		
D	0.210	0.230		.225	.223	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.117	.120	.120		
O	0.540	0.560		.547	.548	.548	.548		
P	0.490	0.510		.500	.501	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.496	2.496	2.496		
S	0.240	0.270		.258	.258	.259	.258		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.565	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by:	<u>F.K.</u>
Date:	<u>17-12-7</u>

Audited by:	<u>A.C.</u>
Date:	<u>17-12-11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		.117	.116	.117	.116		
B	0.100	0.140		.115	.115	.114	.116		
C	0.100	0.140		.117	.117	.118	.117		
D	0.210	0.230		.225	.225	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.496	2.496	2.496		
S	0.240	0.270		.258	.258	.258	.258		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by: PK
Date: 17-12-7

Audited by: B.e
Date: 17-12-11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Outboard, Right side		Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	3	4		
A	0.100	0.140		.116	.117				
B	0.100	0.140		.115	.116				
C	0.100	0.140		.117	.117				
D	0.210	0.230		.224	.225				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.312	.312				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.119	.120				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.496	2.496				
S	0.240	0.270		.259	.259				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.135	1.135				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/				

Measured by:	FK
Date:	17-12-8

Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038646

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038646
PO Date: 12/14/17
Due Date: 12/15/17
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167807	D2938-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
2	167808	D2938-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
3	167804	D2932-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PAR16-484*** SPRAY PAINT BLEU	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
4	167806	D2933-2BL	Saddle RH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
5	167811	D2939-2BL	Saddle RH In, 206 ** MASK ALL HOLES AS PER PAR16-484***	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
6	167803	D2932-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
7	167805	D2933-1BL	Saddle LH In, 206 *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
8	167810	D2939-1BL	Saddle LH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
9	168325-A	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



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PURCHASE ORDER PO038646

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
10	167820-L	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
11	167820-K	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:										\$1,675.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER PO038646

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038646
PO Date: 12/14/17
Due Date: 12/15/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items										
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1	167807	D2938-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
2	167808	D2938-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
3	167804	D2932-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PAR16-484*** SPRAY PAINT BLEU	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
4	167806	D2933-2BL	Saddle RH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
5	167811	D2939-2BL	Saddle RH In, 206 ** MASK ALL HOLES AS PER PAR16-484***	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
6	167803	D2932-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
7	167805	D2933-1BL	Saddle LH In, 206 *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
8	167810	D2939-1BL	Saddle LH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
9	168325-A	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



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PURCHASE ORDER

PO038646

Items										
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			ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
10	167820-L	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
11	167820-K	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:										\$1,675.00

Order Notes

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Plex 1/17/18 10:04 AM dart.baker.diane